Work Order ID 100800 *100800* Page 1 May 1, 2013 7:21:14 AM D3256-1 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Panel Start Qty: 6.00 **Start Date:** 4/30/13 **Cust Item ID:** Required Date: 4/30/13 Req'd Qty: 6.00 **Customer:** Reference: Run Date: B-65-/ Tooling: **Process Plan:** Approvals: Date: OC: SPC (Y/N): Date: Date: uvi ši Seggi Accept neject Reject Insp. Work cente with the Qiy Qty. Ata Froms Number Stamp Draw Nbr **Revision Nbr** D3256 E 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3256 304.032" Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0 QC 0.00 Memo Quality Control DAS

0.00

120

120

Quality Control

QC8- Inspect parts - second check

Memo

DQA:_	Date:
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE	. Data
QA Closed:	Date:
Oisposition AGAINST DEPARTMENT/F	PROCESS
Rework Skid-tube Crosstube Part No. Scrap Machining Small Fab Prod. Use-as-is Thermoforming Finishing Rec/Store	Water Jet Engineering . Eng. Coor. Quality e/Packaging Other Supplier
NCR No Work Order Update Large Fab Composite	Supplier
Root Description of work order update Initial Action Sign &	V. ification OC Investor
Cause Date Step Qty or Non-conformance Chief Eng Description Date	Verification QC Inspector
oc/Data	
etup	
rocess	~
upplier	·
raining	
napproved	
FAULT CATEGORY .	
Landing Gear General Control of the	
Bending Bend Grain Ovalized	Pressure/Forced
Centre Not Concentric to O/S BOM/Route Hardware Over/Under t	—
Cracks Broken/Damaged Inspection Incomplete Part Incorrect	
Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Mis Cuffs Contamination Maintenance Part Moved	Sing Wrong Stock Fulled
	/rong
Heat Treat Countersink Mislabeled Positioned W Inspection Strip in Tube Cut Too Short Misread Power Loss/S	
Ripples in Bend Drill Holes Offset	Total Total
Torque Waves in Extrusion Drawing Out of Calibration	

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

May 1, 2013 7:21:14 AM

Item ID:

D3256-1

Panel Item Name:

Required Date: 4/30/13

Start Date:

Revision ID:

4/30/13

QC:

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

N900040100

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Accept

Tooling:

SPC (Y/N):

Date: Date:

Run

Agect Reject

Setup Start

Number Stamp

Sequent, 170 Work Center and Operation

bescription.

Land Hours

0.00

NC BRAKE

130 Brake NC Brake NC

Memo

Memo

0.00

Qt.

140

130

140 QC

Quality Control

QC5- Inspect part completeness to step on W/O

Form using D3256-1T2

0.00

DAS 27

150

150 Packaging

Packaging

Identify as per dwg & Stock Location: 19 \$\text{A}0.00\$

Memo

0.00

13-12-17

										DQA:	Date	
NCR: Y	es /	/ No				WORK ORDER NON-	CON	NFORM	MANCE / UPDATE			
										QA Closed:	Date	
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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May 1, 2013 7:21:14 AM

Item ID:

D3256-1

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Panel

Required Date: 4/30/13

4/30/13

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Sequence 10/ Work Center 1D Operation Description

Ser Sp/ 100 Rua Hours

1000 11.

fooi# Plan Code .

Qty

Accept Reject Reject Qty

irsp. Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

QC

Memo

0.00

1/12/18 NB-12-18

			DQA:	Date:	
CR.	Ves / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	<u>:</u>
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Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
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Operator			1										
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Other													
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Picklist Print

May 1, 2013 7:21:14 AM

Work Order ID:

100800

Parent Item:

Comments:

Item Name

M304S22GA

304/316 .032 Sheet

D3256-1

Parent Item Name:

Panel

IPP Rev:A

New Issue 07-09-28 EC verified by:DD

IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Purchased

Component Item ID/ Replacement Item ID

Mfg/ Bin Purch Item Last Location

Primary

Location

No

Route Seq ID

100

Unit of Measure Hand

sf

182.1100

Qty on

Loc Code

0.987

Qty per Kit Total

Start Date: 4/30/13

Start Qty: 6.00

6.2336844

Qty

Ac 13.10.14

Date

Issued

Required Date: 4/30/13

Required Qty: 6.00

Qty

Issued

Location Loc Qty 547 1026 185 11 118271 10.76 120866 55.6 121889 115.75

Status

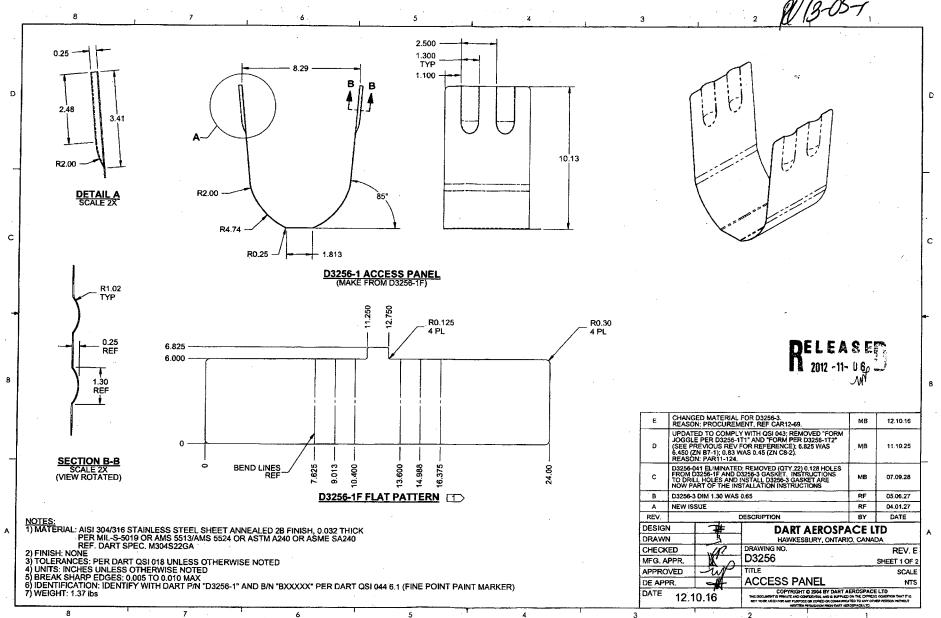
NCR:	Yes	1	No

NCR: Y	ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
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Root		<u> </u>		I	iption of work order update	1	nitial		ction cription	Sign & Date	Verification	QC Inspector
Cause Ooc/Data	Date	Step	Qty		or Non-conformance	1 Cn	ief Eng	Desc	прион	Date	Vermeation	Qe mapeetor
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ļ	Cracks			-	Broken/Damaged	-	i '	ion Incomplete	// / / / / / / / / / / / / / / / / / /	Part Incorre	<u> </u>	Wrong Stock Pulled
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	Wave/T	wist in Tu	be		Folio		Outside	e Dimensions				

DQA: ____ Date: _

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100800 D13-05-1



D R0.13 -4 PL 0.83 1.30 TYP R0.50 12 PL 6.10 4.15 REF 0.65 0.65 -- 24.00 -**D3256-3 GASKET**

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP

3) TOLERANCES: PER DART GSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs

		•	
DESIGN	7	DART AEROSPA	CELTD
DRAWN	3	HAWKESBURY, ONTARIO	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	M.	D3256	SHEET 2 OF 2
APPROVED	ANTA	TITLE	SCALE
DE APPR.		ACCESS PANEL	NTS
DATE 12.	10.16	COPYRIGHT © 2004 BY DART AS THE COMMENT'S PRIVATE AND CONTROL AND IS SUPPLIED OF NOT TO THE USED FOR ANY PLAPOSE OR COPYRIGHT COMMAND.	WITH ROPHESS CONCITION THAT IT IS

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DART AEROSPACE LTD	Work Order:	100800
Description: Access Panel Assembly	Part Number:	D3256-1
Inspection Dwg: D3256 Rev: D	,	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.000	+/-0.010	6.001			V	UKM-05
6.825	+/-0.010	6.825			V	OKIII OS
24.00	+/-0.010	24.00	_			UKM-06
11.250	+/-0.010	11.250			Т	UKM-OB
12.750	+/-0.010	12.750	-		-	

		DAR		
Measured by:	Audited by:	1 1 1 1	Preliminary Approval:	
Date: 13.12.14	Date:	12/13/16	Date:	

Rev	Date	Change		T
			Revised by	Approved
<u> A</u>	07.11.23	New Issue P/O D3256-041	KJ/JLM	
В	08.09.04	Dimensions removed	KJ/DD (A	
С		Dimensions updated per Dwg Rev D		1211
	12.05.14	Dimensions updated per Dwg Rev D	KJ QXI	Z